

Work Order ID 68906

Monday, April 25, 2011 10:52:32 AM



Page 1

Item ID:	D3213-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Panel					
Start Date:	4/25/2011	Start Qty:	8.00		Cust Item ID:	
Required Date:	4/29/2011	Req'd Qty:	8.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-04-25	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3213	Rev A								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3213	<input type="checkbox"/> Dwg Rev: A	<input type="checkbox"/> Prog Rev: A	<input type="checkbox"/> 2-					
20241-063	Deburr if necessary								

HB11-5-3

9

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

HB11-5-3

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

8 1165103

79

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3213-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Panel

Start Date: 4/25/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

x9 0 M 11/05/04

= 7 m-l 11/05/04 (9x)

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Page 3

Item ID: D3213-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Panel

Start Date: 4/25/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/5/5

SP

92

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/6

mf

11-05-05

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NOTE: Date & initial all entries

Picklist Print

Monday, April 25, 2011 10:52:39 AM

Page 1

Work Order ID: 68906



Parent Item: D3213-1



Parent Item Name: Door Panel

Start Date: 4/25/2011

Required Date: 4/29/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 05-11-17 New Issue JLM
IPP Rev:B 07-02-13 Now on Waterjet JLM
IPP Rev C: 08.11.26 Comment added to step 2 KJ Verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

330.5700

0.4714

3.969684



B11-S-3

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

330.57

113867

1.19

117018

41.38

117392

288

117392

9

W/O:		WORK ORDER CHANGES					
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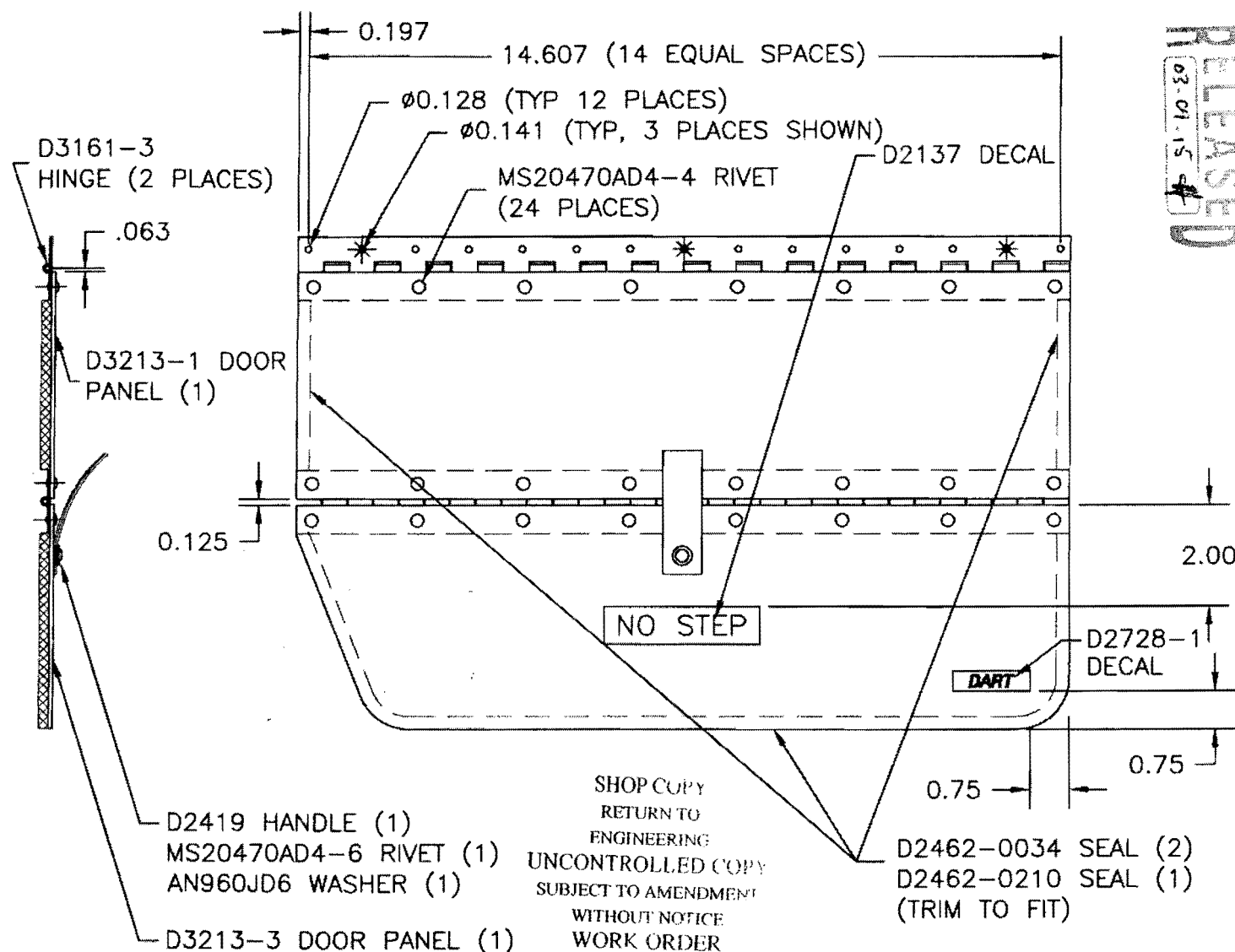
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213
DATE 03.09.03	TITLE DOOR ASSEMBLY	REV. A 1 OF 2
A	03.09.03	NEW ISSUE
		SCALE 1:3

RELEASED
03-01-15



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 98904

011-04-25

D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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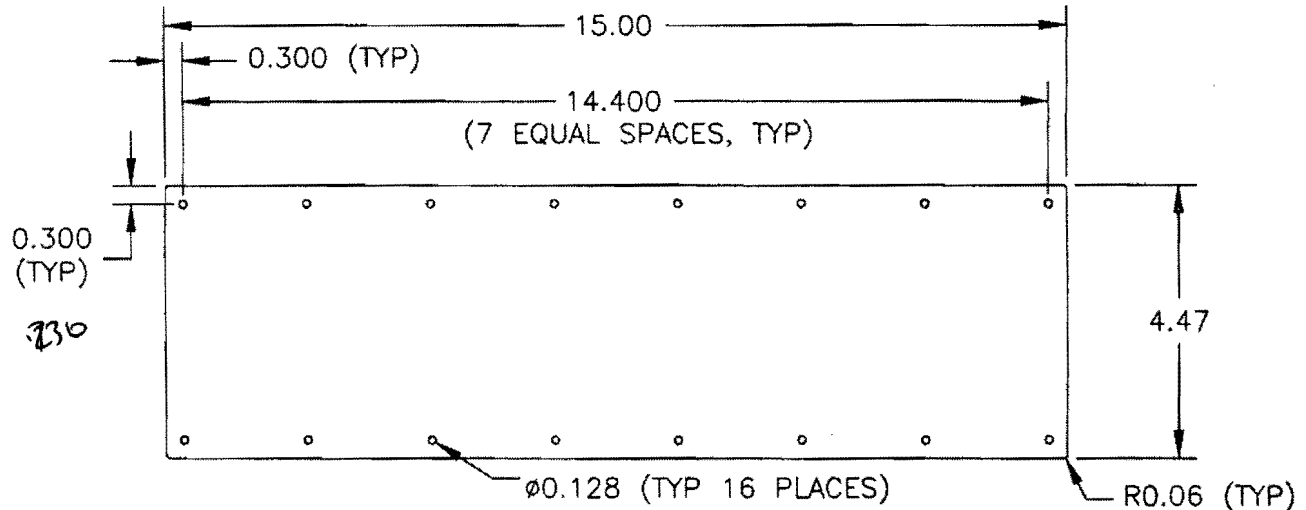
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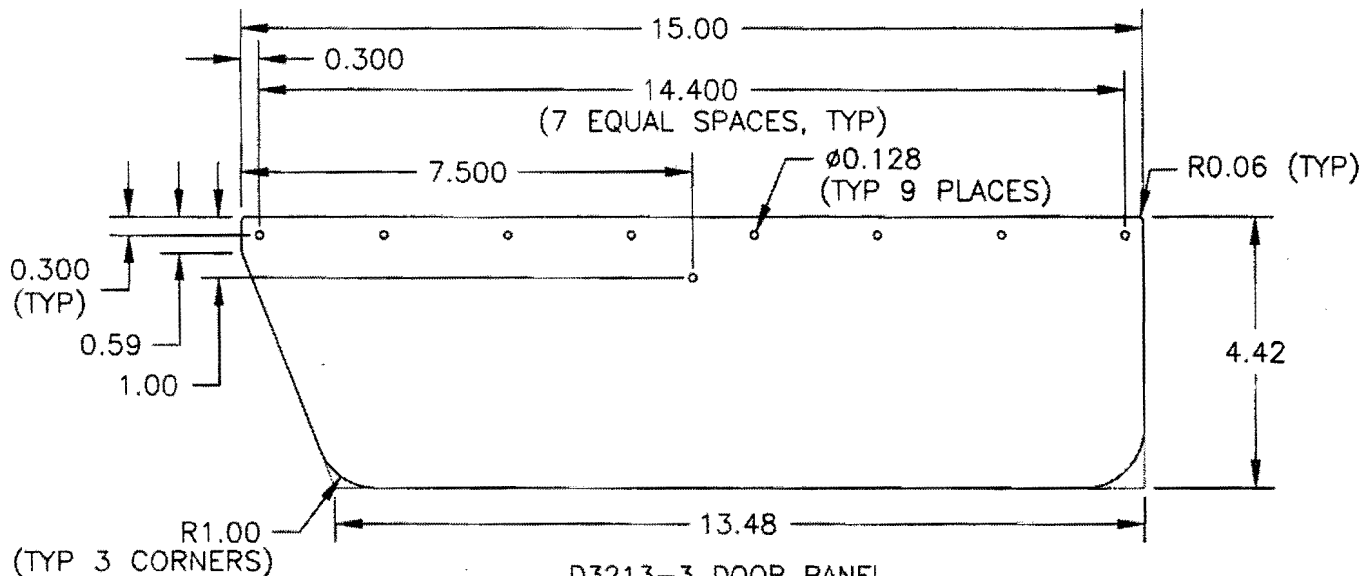


W/O 68904

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.15 [Signature]

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